

Work Order ID 82366

82366

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March-29-12 2:35:34 PM

Item ID: D3391-021
 Revision ID:
 Item Name: Fwd Tube Assembly
 Start Date: 29/03/2012 Start Qty: 1.00
 Required Date: 12/04/2012 Req'd Qty: 1.00
 Reference:

Accept

N900040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 12/03/29 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	I

100		0.00
100	Skidtubes	
Skidtubes	Memo	0.00
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020	

110		0.00
110	BENDING MACHINE - SKIDTUBES	
CNC Bend 1	Memo	0.00
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021	

120		0.00
120	QC5- Inspect part completeness to step on W/O	
QC	Memo	0.00
Quality Control		

DC 12/05/02

DC 12/05/02

JP 12-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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82366

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N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 29/03/2012 **Start Qty:** 1.00 ***1***

Required Date: 12/04/2012 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

~~9~~ 12-05-07

160

0.00

0.00

170

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 1.00 ***1***
Required Date: 12/04/2012 Req'd Qty: 1.00 ***1***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

180

Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

NO WEARPLATE HOLES ARE TRANSFER DRILLED

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. N. 12/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 82366

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Item ID: D3391-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Tube Assembly

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.00

Hand Finishing

1 746 12-6-20

210

QC7-Inspect Chemical Conversion Coat

0.00

210

QC

Memo

0.00

Quality Control

① SAM 12-06-22

220

Skidtubes

0.00

220

Skidtubes

Memo

0.00

Skidtubes

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch: M120666exp. date: 13-1-30

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

DC 12/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							1 7/6 12-6-27
235 *235* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo AND REALODINE AS PER PAR09-043	0.00 0.00							1 7/6 12-6-27
240 *240* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 1:15 OVEN TEMPERATURE: 320° FINISH TIME: 45	0.00 0.00							1 0 12-6-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 1.00 ***1***

Required Date: 12/04/2012 Req'd Qty: 1.00 ***1***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling:

_____ Date: _____

SPC (Y/N):

_____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							
Quality Control									
255		0.00							
255	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	**** install D3591-1 spacer as per DSI9364 and wearplate as per DWG ****								
257	QC5- Inspect part completeness to step on W/O	0.00							
257									
QC	Memo	0.00							
Quality Control									

1x 4 All 12/07/03

1x 4 All 12/07/03

8/26/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D3391-021 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Tube Assembly
 Start Date: 29/03/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/04/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
260									
Packaging	Memo	0.00							
Packaging									
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

CK 12/7/6.

MF
12-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 82366

82366

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM
IPP B06.02.10Dwg rev.D ecn 773 EC
IPP C06.05.02Added inspections EC
IPP D 07.03.13 rev F dwg EC
IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J
11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-051		Manufactured	No			255	Each	13.0000	1	1			
D4095-051													
Wearpad Assembly													

Location

Loc Qty

Loc Code

FP001

3

1381613

XL

78821

3

FP002

10

78914

10

D6013-047		Manufactured	No			100	Each	102.0000	1	1			
D6013-047													
Skidtube Material													

Location

Loc Qty

Loc Code

LG

102

72505

102

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82366

82366

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

220

Each

103.0000

4

4

D3670-4-200

SPACER

**

DC 12/06/22

Location

B84504

Loc Qty

Loc Code

LG

76

80360

76

LG001

27

72851

3

78606

24

(4)

D3401-041

Manufactured No

255

Each

6.0000

1

1

D3401-041

Tow Cap Assembly

**

11/07/03

Location

Loc Qty

Loc Code

FP002

6

78990

6

B83432

X1

AN960C10L

NAS1149C0332
R

Purchased

No

255

Each

0.0000

10

10

*AN960C10I *

washer

11122063

**

(X10) 11/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

255

Each

3,174.000

10

10

AN3C4A

BOLT

**

ME 12/07/03

Location

Loc Qty

Loc Code

ST350

3174

117688

5

118112

16

119749

10

120187

1992

120423

10

120521

64

120769

38

120799

23

120930

16

121205

1000

X10

D3672-1

Manufactured

No

255

Each

1,038.000

4

4

D3672-1

Phenolic Washer

**

ME 12/07/03

Location

Loc Qty

Loc Code

FP001

34

66821

34

ST060

1004

72229

4

76277

500

80369

500

X4

AELS-1032-225

Purchased

No

255

Each

0.0000

10

10

AFI S-1032-225

INSERT

X AELS-1032-225 / M118520

**

(X10) ME 12/07/03

March-29-12 2:35:38 PM

Shop Packet Print

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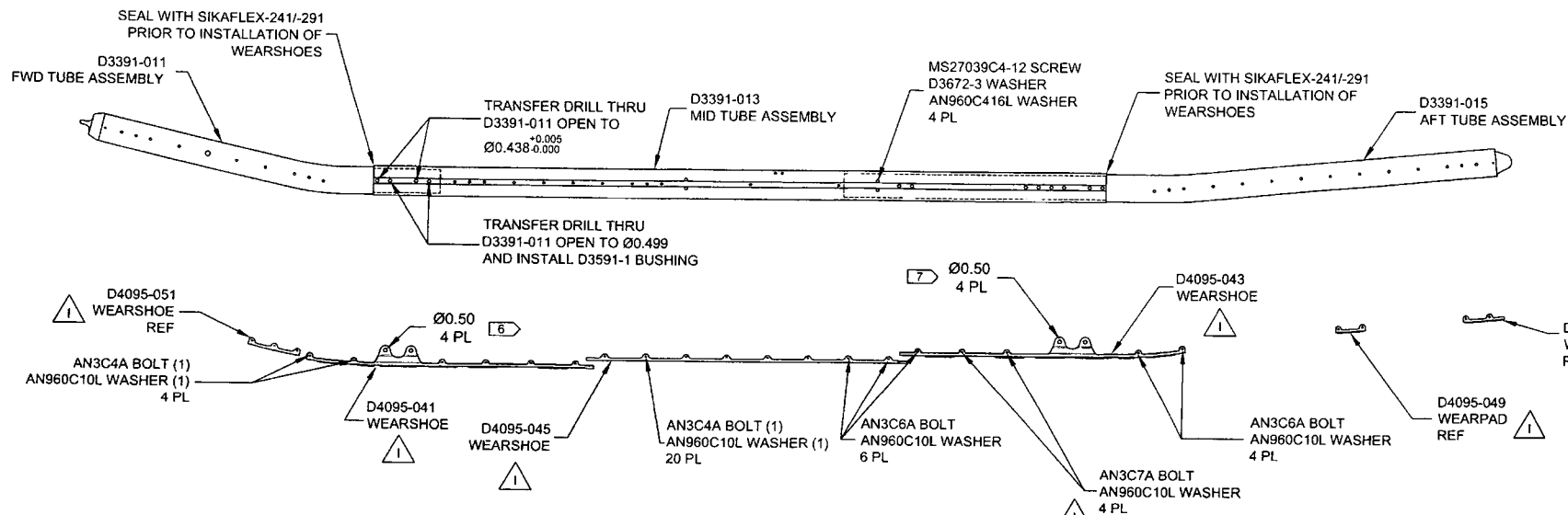
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D3391-041 ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 823666 MCW 12/03/29

RELEASED
2011-11-04
ECN# 41-662

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

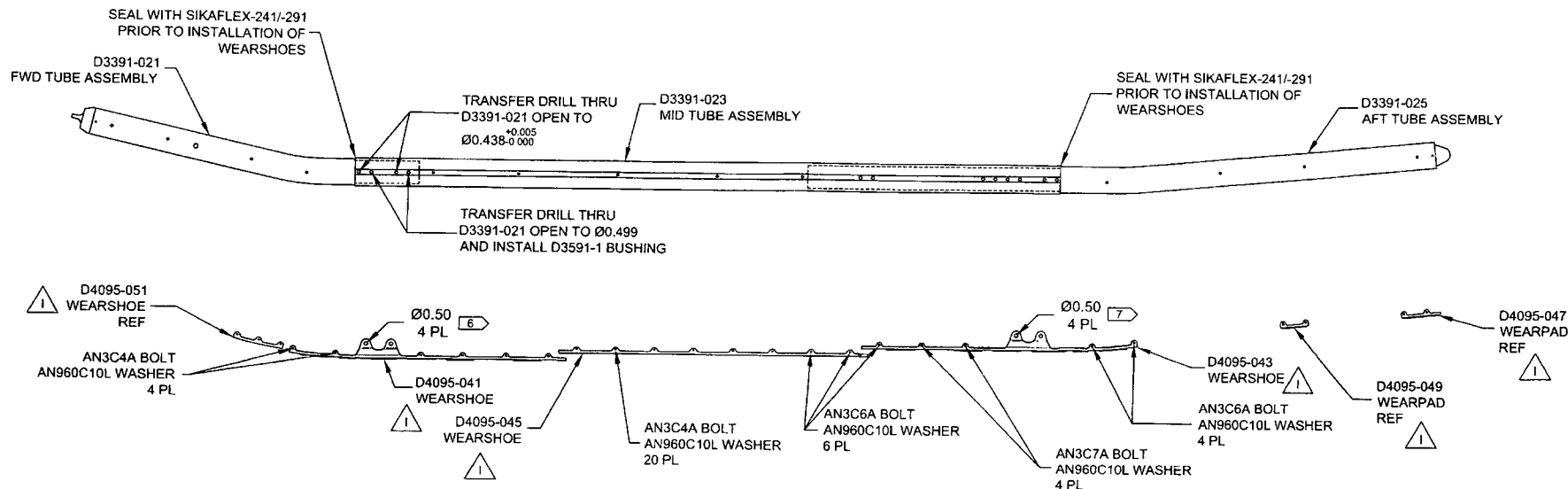
QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	Float Skidtube Assembly
1	D3391-011	FWD Tube Assembly
1	D3391-013	MID Tube Assembly
1	D3391-015	AFT Tube Assembly
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES: PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC KENT, WA	
DRAWN	XDF		
CHECKED		DRAWING NO	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHEN ISSUED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

82366



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

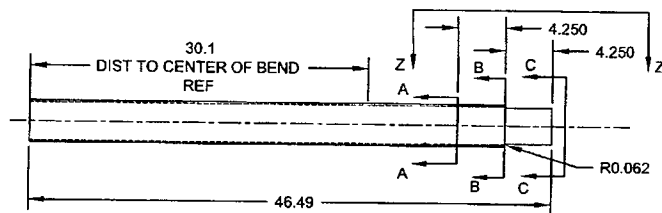
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

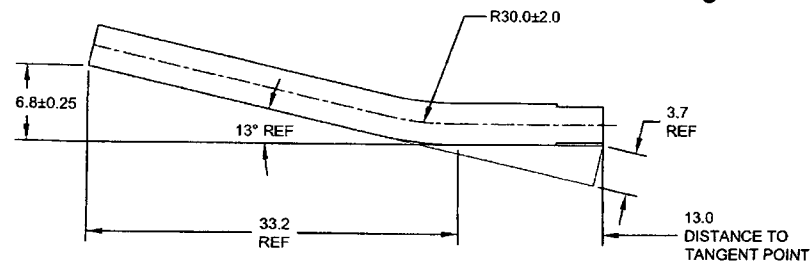
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

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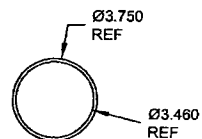
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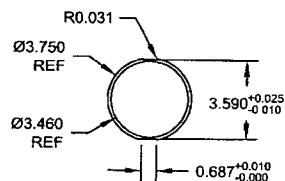
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



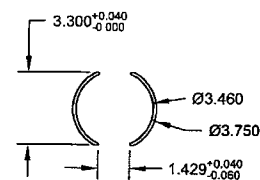
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



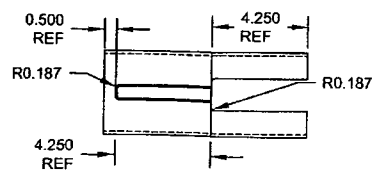
SECTION A-A
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SECTION B-B
SCALE 2X



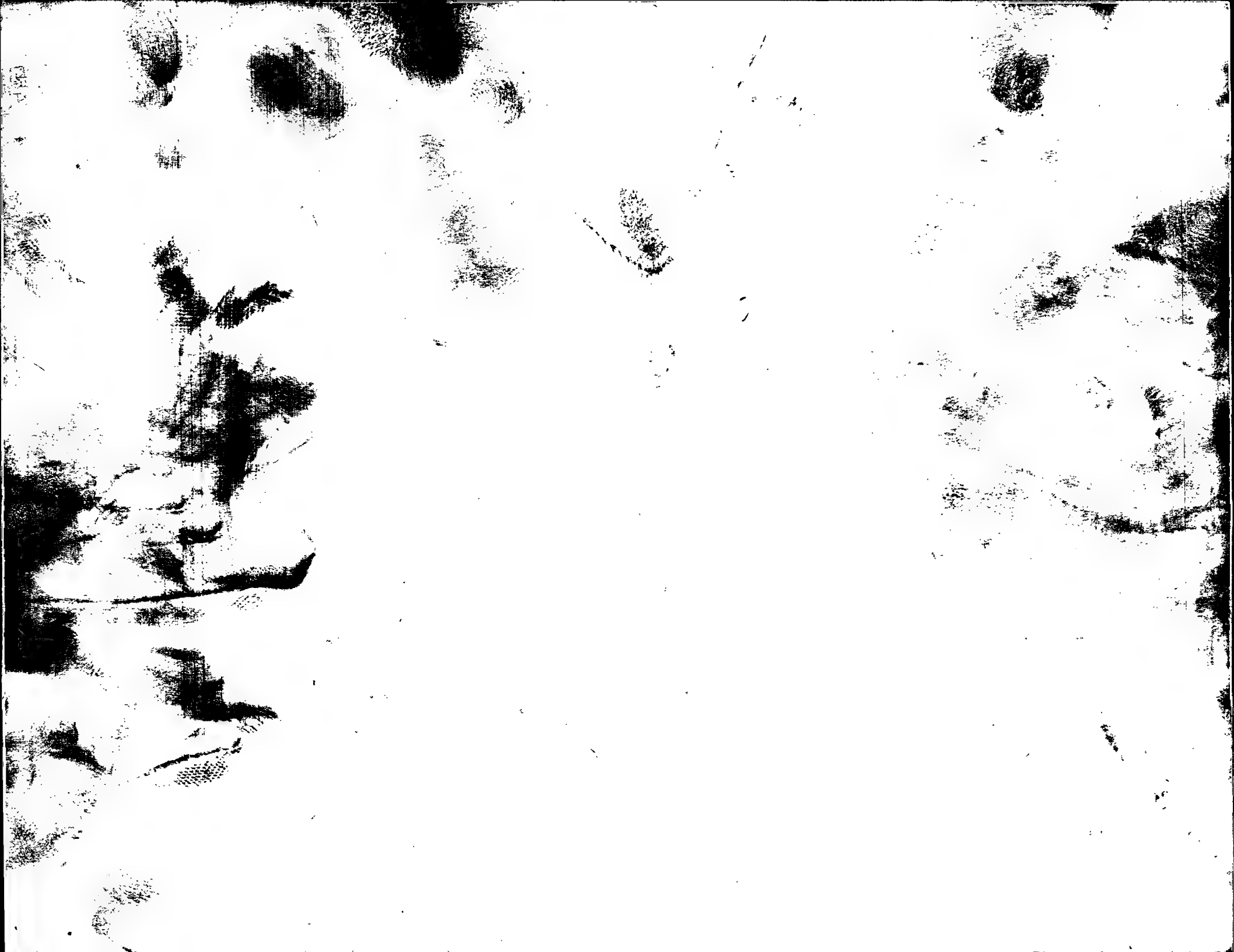
SECTION C-C
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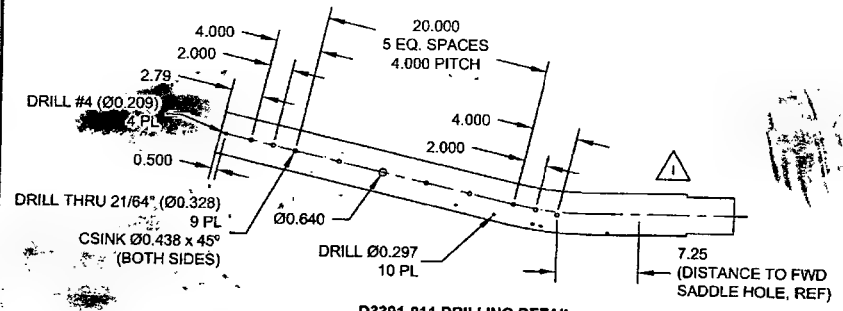
VIEW Z-Z
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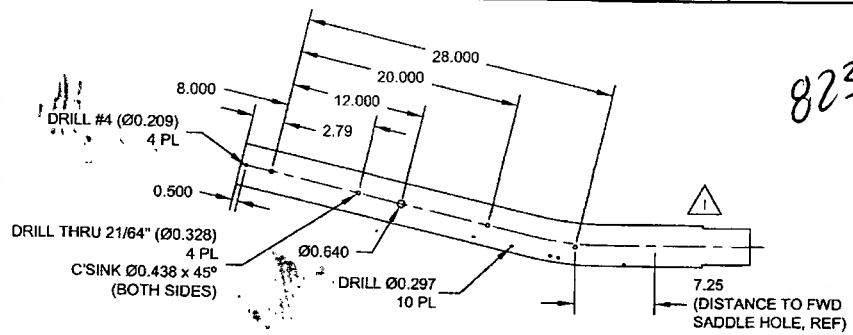
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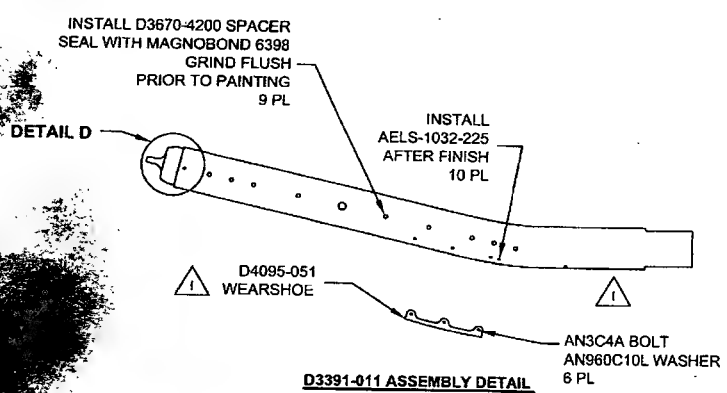
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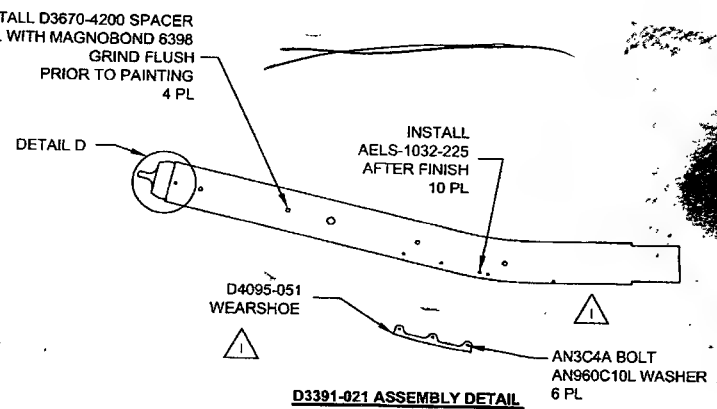
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



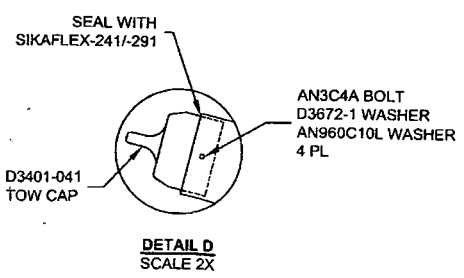
D3391-011 ASSEMBLY DETAIL



D3391-021 ASSEMBLY DETAIL

D3391-011/021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT

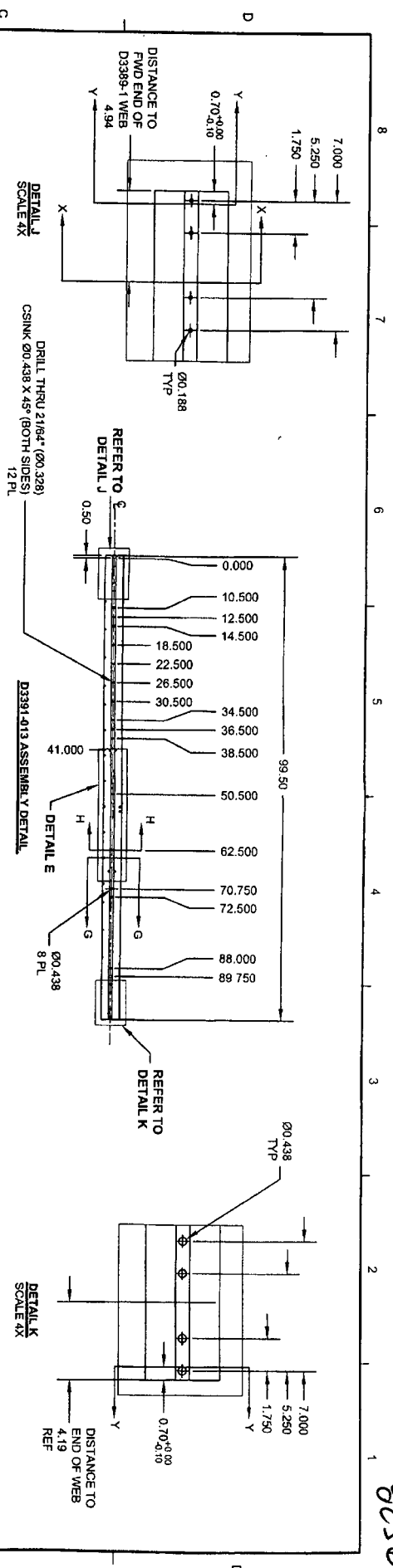


**DETAIL D
SCALE 2X**

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D3391-013 MID TUBE ASSEMBLY PARTS LIST

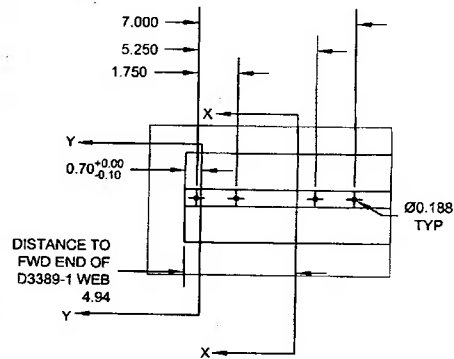
QTY	PART NUMBER	DESCRIPTION
1	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3689-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

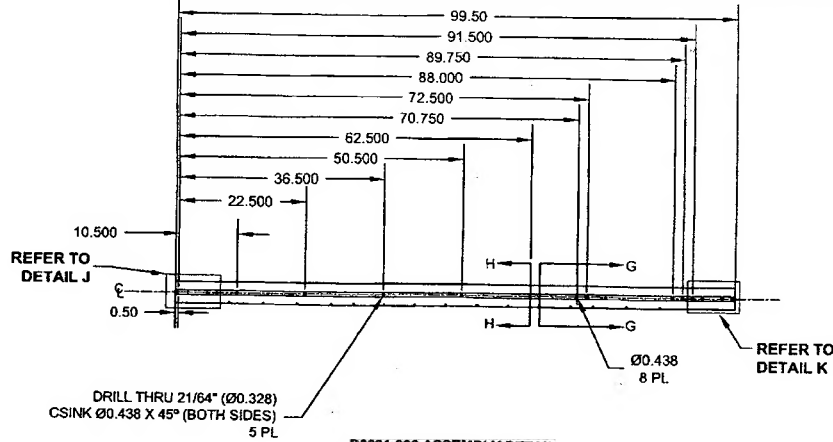
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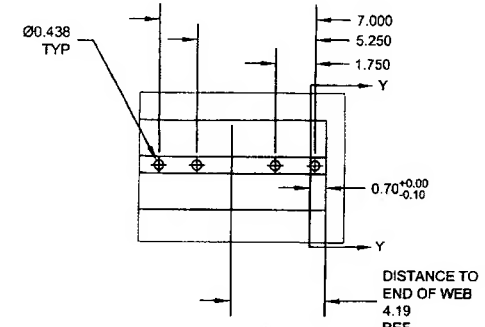
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DETAIL J
SCALE 4X



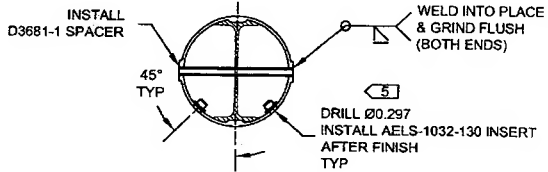
D3391-023 ASSEMBLY DETAIL



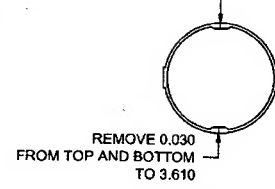
DETAIL K
SCALE 4X



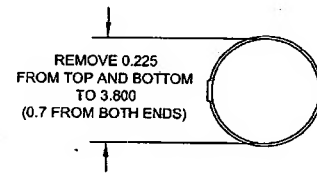
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

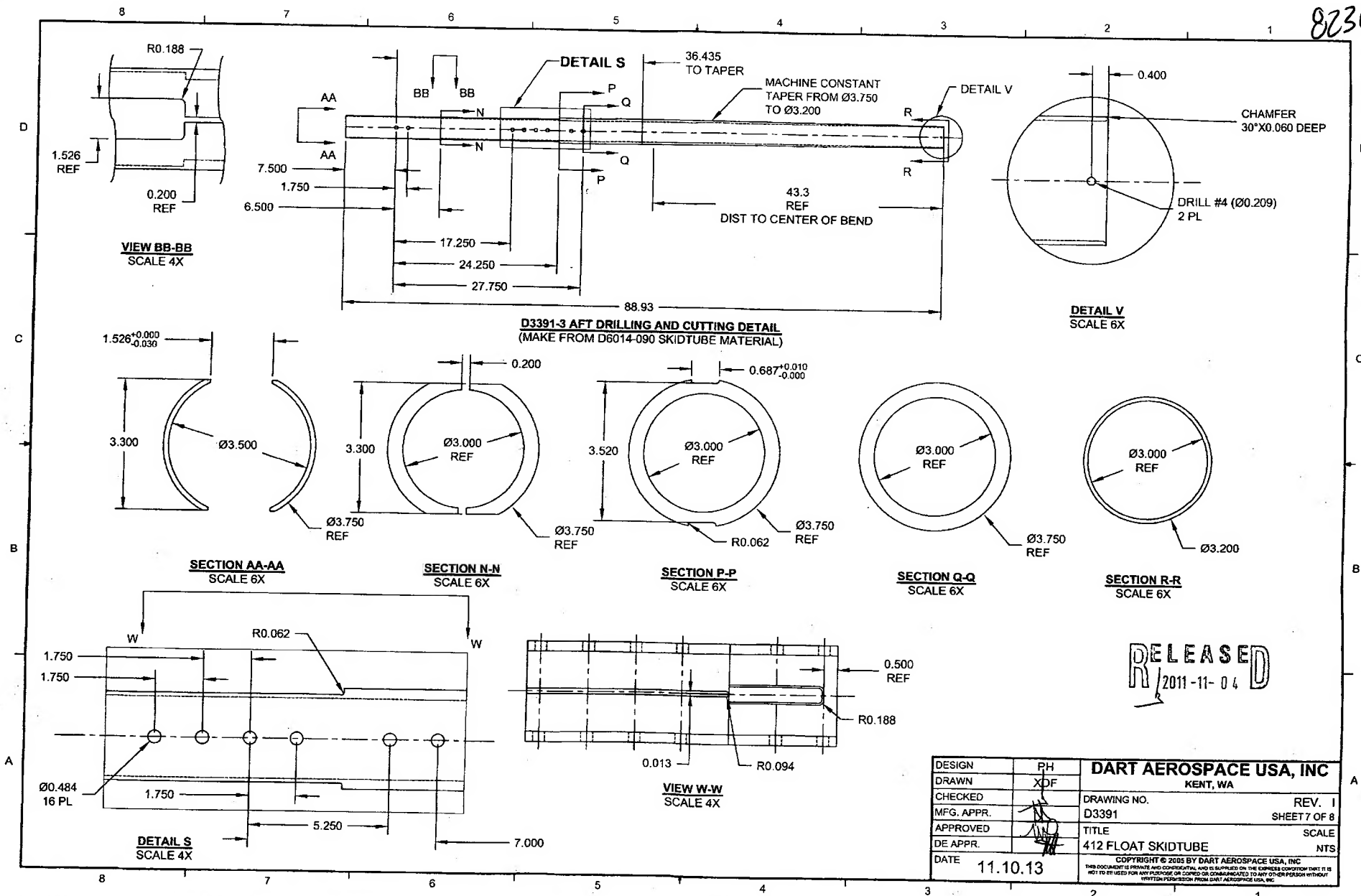
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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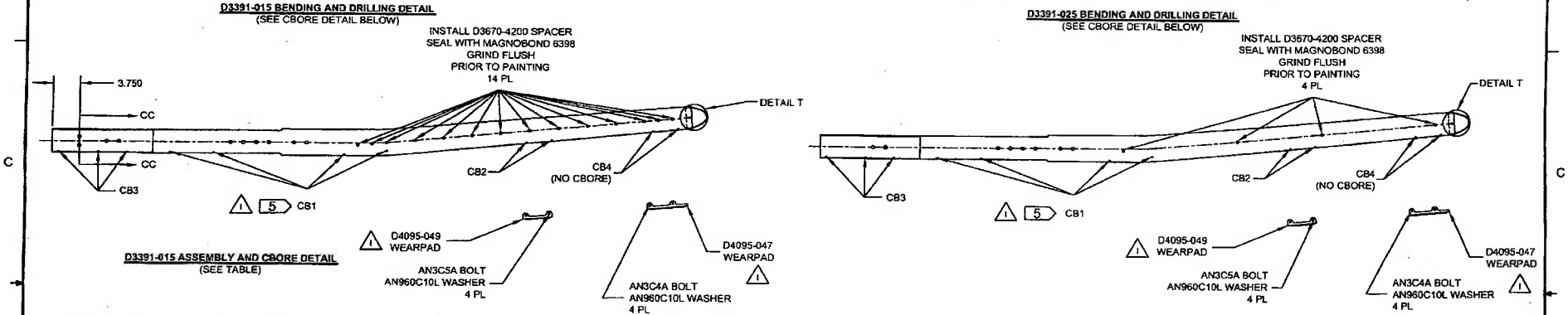
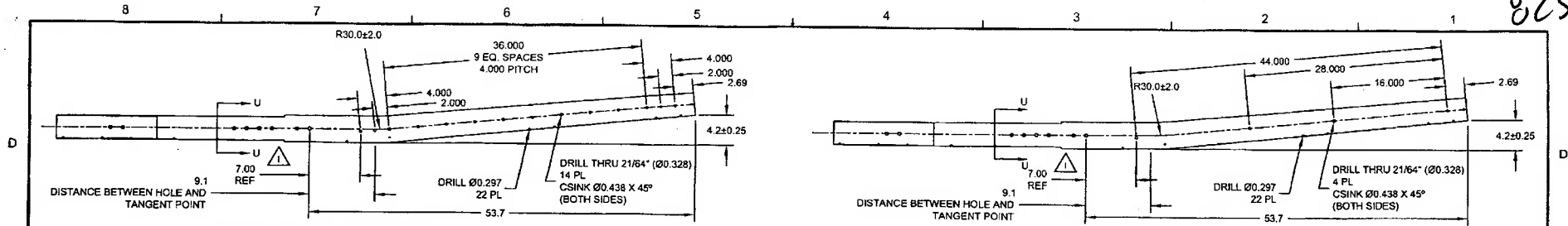
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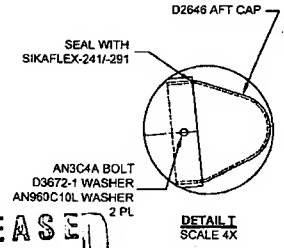
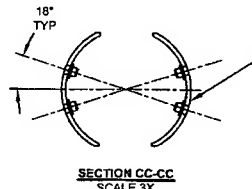
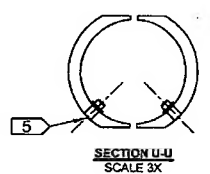


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN860C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130



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